

Work Order ID 76496

76496

Page 1

Tuesday, November 15, 2011 3:59:48 PM

Item ID: D3325-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 11/15/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/25/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: / Date: 11-15 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3325	Rev B

100	Large Fab	0.00							
100									
Large Fab									
Large Fab									

Memo

1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
	2D3325-1	End Tube	<u>112786</u>
	3D3325-3	Interior Tube	<u>112786</u>
	2D3325-5	Full Length Tube	<u>112786</u>

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004
 A/R4130 Steel Rod 118875

4-Deburr as required

11/11/23 1/2 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76496

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							

130

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME: 8:20

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:50

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 8:50

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:00

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

Handwritten: NO M-11/11/24

Handwritten: EP 11/11/24 (2)

Handwritten: M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
150									
Packaging	Memo <i>w/o</i>	0.00							
Packaging	<i>76488</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/11/24 (2)

11/11/28

11/11/25 (1)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, November 15, 2011 3:59:53 PM

Page 1

Work Order ID: 76496

76496

Parent Item: D3325-041

D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-1 *D3328-1* Basket Hinge		Manufactured	No			100	Each	17.0000	2	2	**	Pl 11.11.23	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				17					
				33871				17					
D3349-1 *D3349-1* Spacer Bushing		Manufactured	No			100	Each	22.0000	2	2	**	Pl 11.11.23	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				22					
				44401				22					
D3352-1 *D3352-1* Label Plate		Manufactured	No			100	Each	11.0000	1	1	**	Pl 11.11.23	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				11					
				41925				11					
D3367-1 *D3367-1* Mounting Bracket		Manufactured	No			100	Each	8.0000	2	2	**	Pl 11.11.23	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				8					
				43228				8					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 76496

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Parent Item: D3325-041

D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

307.3682

20.5416

21.62274

M4130NTS0 500W 035

**

Handwritten signature

4130 Square tube .500 x .500 x .035w

Location

Loc Qty

Loc Code

MAT034

307.3682

109127

158.152

109385

15.75

112786

39.2488

119441

57.8774

119506

36.34

21.6227

Tuesday, November 15, 2011 3:59:53 PM

Shop Packet Print

Page 2

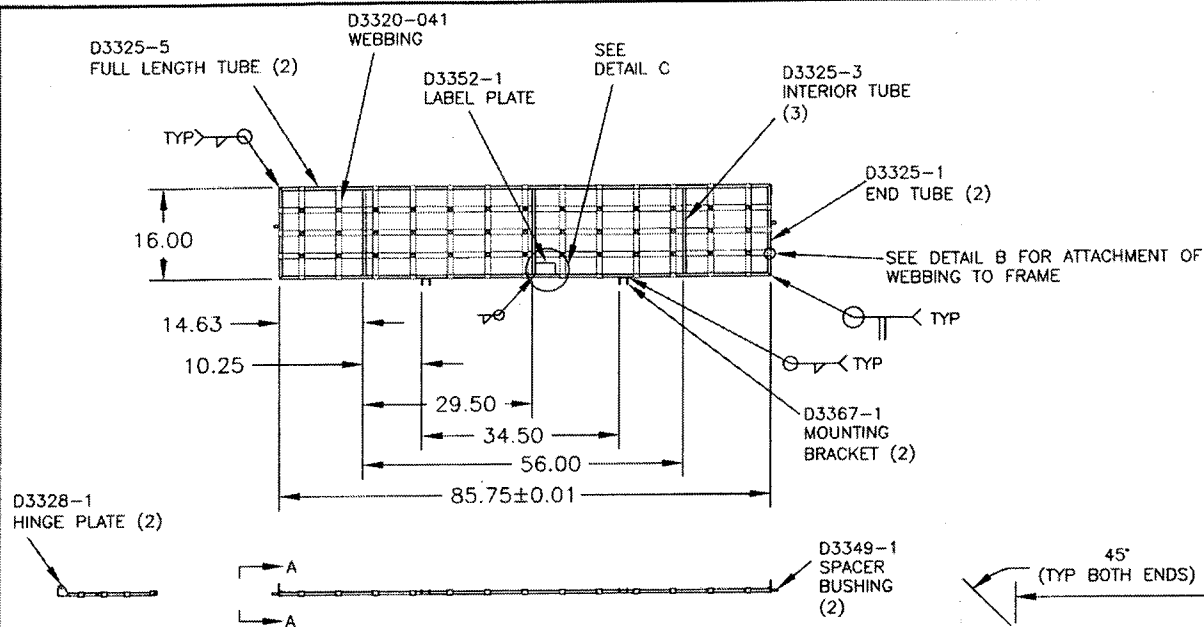
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

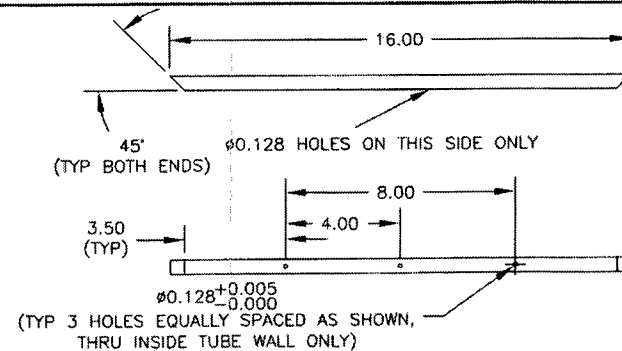
PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN880J09	32	WASHER

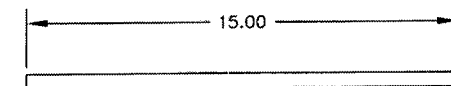
RELEASED
05-04-25

DEO ATTACHED

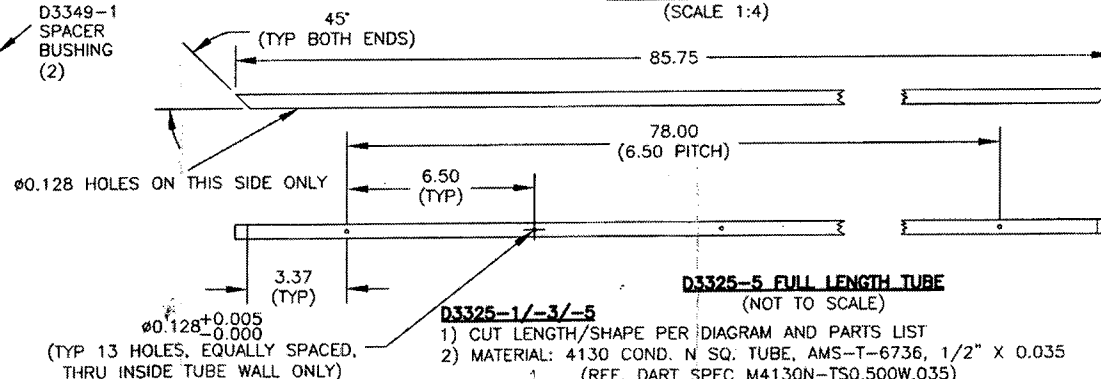
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76494



D3325-1 END TUBE
(SCALE 1:4)



D3325-3 INTERIOR TUBE
(SCALE 1:4)



D3325-5 FULL LENGTH TUBE
(NOT TO SCALE)

D3325-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	D41	DART
DRAWN BY	PH	DART AEROSPACE LTD.
CHECKED	PH	DART AEROSPACE LTD.
APPROVED	PH	DART AEROSPACE LTD.
DATE	05.04.25	BASKET LID ASSEMBLY
DRAWING NO.	D3325	REV. B
TITLE	BASKET LID ASSEMBLY	SHEET 1 OF 3
SCALE	1:20	

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11-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

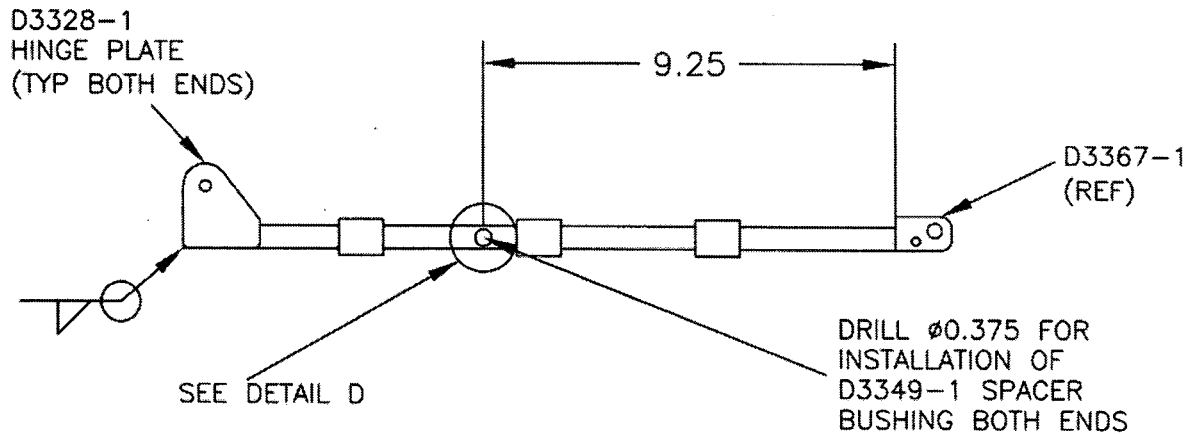
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

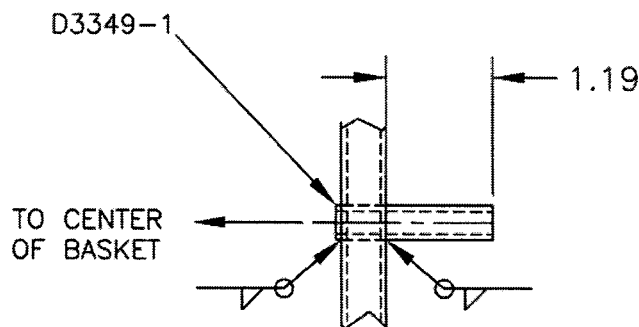


DESIGN AH	DRAWN BY AH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A

13276



DETAIL D
(SCALE 1:2)

DEO ATTACHED
RELEASED
05.04.28 #

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

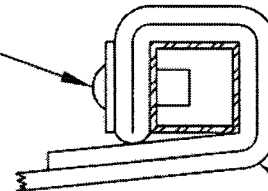
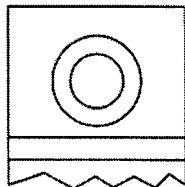
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN AH	DRAWN BY AH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AH	APPROVED AH	DRAWING NO. D3325	REV. 8 SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)



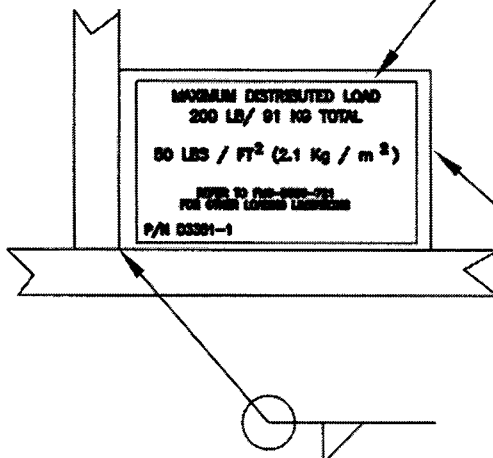
DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

96466

RELEASED
05.04.28 AH
DEO ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

MS20600AD4W5	32	RIVET

WAS:

MS20600AD4W3	32	RIVET

16496

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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